Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3278-1
Job Sheet 205592

Part No: D3278-1
Part Name: Support
Part Weight: 0 lbs
Job Created: 1/14/20
Due Date: 3/13/20
Type: Stock

Job Qty: 40 pcs
DAS 21 9-80
Status: New
Job Tracking No:
Created By: Marie Lajeunesse
Description:

Priority: Medium

Note: DWG REV C IPP: A 04.04.19 New issue KJ/JLM IPP B 07.09.06 rev.c dwg EC verified by: JLM
Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Standard Run Hrs	Workcenter/Supplier	Lead Time	Sign-off
100	**Bandsaw - 1**	40 pcs		3/13/20	0.00	1.16	Bandsaw - 1		BM 20-01-18
110	**HAAS 5 Axis - B4B**	40 pcs		3/13/20	0.50	4.80	HAAS - 1 - 5 - B4B HAAS - 2 - 5 - B4B		
135	**QC 8**	40 pcs		3/13/20	0.00	0.00	QC 8 - 12 QC 8 - 14 QC 8 - 17 QC 8 - 20 QC 8 - 25 QC 8 - 3 QC 8 - 32 QC 8 - 33 QC 8 - 35 QC 8 - 39 QC 8 - 4 QC 8 - 44 QC 8 - 45 QC 8 - 49 QC 8 - 58 QC 8 - 8 QC 8 - 9 QC 8 - 66 QC 8 - 67 QC 8 - 1 (A) QC 8 - 47 QC 8 - 40 QC 8 - 52 QC 8 - 23 QC 8 - 57 QC 8 - 76		
140	**Handfinish - 1-1 Chemical-B4B**	40 pcs		3/13/20	0.00	0.38	Handfinish - 1 - 1 - B4B		

DART AEROSPACE
Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S248555
Part: D3278-1
Job No: 205592
Serial No/Batch: S248555
Revision: REV.C
Inspector:
Exp Date:
Instructions: Various STC's
Date: 01/18/20

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K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3278-1
Job Sheet 205592

Part No: D3278-1 **Job Qty:** 50 pcs
Part Name: Support

Part Weight: 0 lbs **Status:** Scheduled **Priority:** Medium
Job Created: 1/14/20 **Job Tracking No:**
Due Date: 3/13/20 **Created By:** Marie Lajeunesse
Type: Stock **Description:**
Note: DWG REV C IPP: A 04.04.19 New issue KJ/JLM IPP B 07.09.06 rev.c dwg EC verified by: JLM
Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Standard Run Hrs	Workcenter/Supplier	Lead Time	Sign-off
100	**Bandsaw - 1**	50 pcs		3/13/20	0.00	1.44	Bandsaw - 1		
110	**HAAS 5 Axis - B4B**	50 pcs		3/13/20	0.50	6.00	~~HAAS - 1 - 5 - B4B~~		
							HAAS - 2 - 5 - B4B		Not Require
120	**Outsource - 5 - Machining**	50 pcs		3/13/20			MEM001-VC		1/27/2020
125	**Packaging 2-1 - Receive - B4B**	50 pcs		3/13/20	0.00	0.00	Packaging 2 - 1 - B4B		SEE PAGE 3 OF 4
130	**QC 6**	50 pcs		3/13/20	0.00	0.00	QC 6 - ~~61~~ 82		APR 14 2020
135	**QC 8**	50 pcs		3/13/20	0.00	0.00	QC 8 - 12		
							QC 8 - 14		Not Require
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		

DAS 82 9-89

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					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
					QC 8 - 76	
140	**Handfinish - 1-1 Chemical-B4B**	50 pcs	3/13/20	0.00 0.48	Handfinish - 1 - 1 - B4B	BEB 2-04-15
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
	M95 4468.					
150	**Powdercoat - 1 White Gl(A)-B4B** ~~M455~~	50 pcs	3/13/20	0.00 0.37	Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	2-04-15
	START: 1:30 OUT: 300° FINISH: 2:00.				Powdercoat - 4 - B4B	
160	**QC 3**	50 pcs	3/13/20	0.00 0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	

DMS 3-4 9-89

				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	DAS
				QC 3 - 40	APR 15 2020 40
				QC 3 - 19	9-89
				QC 3 - 43	
				QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
170 **Packaging 3-1 - Stock - B4B**	50 pcs	3/13/20	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	DAS
				Packaging 3 - 3 - B4B	SA1780 APR 16 2020
				Packaging 3 - 4 - B4B	9-89
				Packaging 3 - 5 - B4B	FEB 18 2020
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
180 **QC 21 - SA**	50 pcs	3/13/20	0.00 0.00	QC 21 - SA - 21	SA117
				QC 21 - SA - 70	DAS
				QC 21 - SA - 53	21 9-89 APR 17 2020

Part Op Descriptions:
100 - (Bandsaw) Cut blank: 2.00" x 1.00" x 2.550" long
110 - (HAAS CNC vertical machine #5) 1- Machine as per Folio FA405 and Dwg D3278 2- Deburr and Tumble Identify as D3278-1
120 - (Outsource process - Machining)
125 - (Receive & Inspect for Damage & Mat'l Certs)
130 - (QC6- All purchased or subcontracted products)
140 - (Chemical Conversion Coat per QSI005 4.1)
150 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: _____ OVEN TEMPERATURE:

10 HBO 45695 x 50 Plus 27 Jan 2020

_____ FINISH TIME: _____
160 - (QC3- Inspect Part Finish)
170 - (Identify as per dwg & Stock Location:_____) LOCATION : GA
180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.000X02.000	6061-T6 Bar 1.00 X 2.00	10.8500 ft (.217 ea)	100-Bandsaw - 1	S240677

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M6061T6B1.000X02.000	11	18	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Support	0.098inches + 0.005 - 0.000	0.103 0.098	.098	
2	Support	0.359inches ± 0.005	0.364 0.354	.363	
3	Support	0.609inches ± 0.010	0.619 0.599	.609	
4	Support	0.250inches ± 0.010	0.260 0.240	.251	
5	Support	1.480inches ± 0.005	1.485 1.475	1.481	
6	Support	0.125inches ± 0.010	0.135 0.115	.126	
7	Support	0.119inches + 0.005 - 0.004	0.124 0.115	.119	
8	Support	2.439inches ± 0.010	2.449 2.429	2.435	
9	Support	1.980inches ± 0.010	1.990 1.970	1.979	
10	Support	0.130inches ± 0.030	0.160 0.100	.132	
11	Support	0.257inches + 0.005 - 0.000	0.262 0.257	.257	
12	Support	0.375inches ± 0.010	0.385 0.365	.375	
13	Support	0.875inches ± 0.010	0.885 0.865	.876	
14	Support	0.500inches ± 0.010	0.510 0.490	.504	
15	Support	0.400inches ± 0.010	0.410 0.390	.400	
16	Support	1.000inches ± 0.030	1.030 0.970	1.000	
17	Support	1.720inches ± 0.010	1.730 1.710	1.720	
18	Support	0.125inches ± 0.010	0.135 0.115	.125	
19	Support	0.125inches ± 0.010	0.135 0.115	.126	

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No.

Route update only ☐

Job: _____

Part No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐

DEPARTMENT/PROCESS

Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Water Jet ☐
Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Supplier ☐
Quality ☐

Date :	Sequence #:	QTY Affected :	MRB (QSI042)

Description Work Order Deviation	Disposition	Completed By
		Lead hand / Supervisor
		QC / QA Coordinator

Root Cause

Operator ☐
Manufacturing Process ☐
Equip/Tooling ☐
Handling/Presservation ☐
Material ☐
Product Improvement ☐
Process Improvement ☐
Human Factors ☐

FAULT CATEGORY

☐ Pressure/Forced ☐ Contamination ☐ Power Loss/Surge ☐ Positioned Wrong
☐ Bending ☐ Misaligned/off center ☐ Folio/Program ☐ Outside Tolerance
☐ Crushing ☐ BOM/Route ☐ Grain Direction ☐ Drawing
☐ Cracks ☐ Broken/Damage/Defect ☐ Weld ☐ Finish
☐ Crimp/Kink/Ripple/Wave/Twist ☐ Incomplete/Unclear Instructions ☐ Wrong Stock Pulled ☐ Part Lost/Missing
☐ Marks/Chatter ☐ Drill Holes ☐ Out of Sequence ☐ Misread
☐ Mislabeled ☐ Fit/Function ☐ Off-set/Set-up

Other/Details:

Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER
POHB045695

Supplier: MEM001-VC
Metec Metal Technology Inc.
20 Terry Fox Drive PO Box 781
Vankleek Hill
ON
K0B 1R0 Canada
Phone: 613 678 3957
Fax: 613 678 3956

Attention: Walz, Shigi

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB045695
PO Date: 1/27/20
Due Date: 3/2/20
Purchase Order Revision:
Revision Date:
Ship-To Contact: Phone:
Via: Ground
Pymt Terms: Net 60
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Drawing	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	205592	D3278-1	D3278 REV.C			Support : Various STC's (Outsource process - Machining)	Firmed XSO	-	3/2/20	50 pcs	0 pcs FEB 18 2020	50 pcs	$46.94/pcs	$2,347.00
Line Item Note	no paint no alodine Rush													
2	205593	D3278-2	D3278 REV.C			Support : Various STC's	Firmed XSO	-	3/2/20	50 pcs	0 pcs FEB 18 2020	50 pcs	$46.94/pcs	$2,347.00
Line Item Note	no paint no alodine Rush													
													Grand Total:	**$4,694.00**

Order Notes

Procurement Quality Clauses
A005 RIGHT OF ENTRY
A008 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION SENT TO DART AEROSPACE)
A012 CHEMICAL AND PHYSICAL TEST REPORTS
A016 PERSONNEL QUALIFICATION
A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
A026 CERTIFICATION OF MATERIAL CONFORMANCE
A041 QUALITY MANAGEMENT SYSTEM
A042 DART NOTIFICATION BY SUPPLIER
A043 RETENTION OF QUALITY DOCUMENT
A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM
A049 SUPPLIER AWARENESS

Terms & Conditions of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 1/27/20 11:32 AM dart.lussier.patrick

Robert Aboud Digitally signed by Robert Aboud Date: 2020.01.27 15:18:53 -05'00'

METEC METAL TECHNOLOGY INC.
20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0
Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

Quantity	Part Number	Part Name	Dwg Rev.#	Material Batch #	Paint Batch #	P.O. Number
50	D3278-1P	Support	C	S248555	unpainted	HB45695
50	D3278-2P	Support	C	S248553	unpainted	HB45695

MATERIAL: supplied by DART

DAS
82
9-89

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Heather Nixon

Heather Nixon

Vankleek Hill, February 12, 2020

METEC METAL TECHNOLOGY INC.

www.metec.ca | 20 Terry Fox Drive, Vankleek Hill, Ontario, Canada K0B 1R0 | Phone: +1 613-678-3957 Fax: +1 613-678-3956

Packing List

Bill To: **Dart Aerospace Ltd.**
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Ship To: **Dart Aerospace Ltd.**
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Shipment No:	**26760**	**Customer Code:**	DART
Shipment Date:	12-Feb-2020	**Phone:**	(613) 632-9577
Ship Via:	Pick up at METEC	**PO Number:**	**POHB45695**
Order Number:	4566		
Order Date:	01/28/2020	**Terms:**	Net 60 Days

	Quantity							
Item	Open	Shipped	B/O	Canceled	Unit	Description	Revision	Job Number
1	50	50	0	0	EA	DART-D3278-1P Support, unpainted	C	4566-01
2	50	50	0	0	EA	DART-D3278-2P Support, unpainted	C	4566-02

RECEIVED
FEB 14 2020
DART AEROSPACE LTD.

The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.

Heather Nixon

Packing Clerk's Signature
Metec Metal Technology Inc

Received In Good Order By
Dart Aerospace Ltd.